

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001959**Date Inspected:** 14-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Bay 2 New OBG Bldg**CWI Name:** C.M. Chen 03110711**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Side & Bottom Deck Panels**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Mr. David Kelsey (QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe Quality Control Inspector Mr. C.M. Chen (QC Inspector) of ZPMC perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP) and the Contract Special Provisions and to randomly inspect the in-process welding fabrication of the Orthotropic Box Girder (OBG) side and bottom plates.

The Caltrans QA Inspector performed in-process visual inspection on the submerged arc welding (SAW) multiple cover pass welds joining the side plates SP013-PL73 A/B to the SP021-PL78 A/B.

The Caltrans QA Inspector performed in-process visual inspection on the submerged arc welding (SAW) multiple cover pass welds joining the bottom plates BP001-PL33A to the BP002-PL34A.

Bay 2 New OBG Building:

The Caltrans QA Inspectors observed in-process welding of the previously mentioned bottom and side plates within the parameters set forth in the WPS-B-T-2221-B-L2C-S1. QA Inspector observed the ZPMC QC Inspector monitoring welding voltage, pre-heat & interpass temperatures, weld pass width, profile/size and travel speed. QA Inspector checked the CWI & welder qualifications and randomly verified pre-heat & interpass temperatures, welding position, welding voltage, weld profile, size and interpass cleaning. The in-process welding observed appears to comply with WPS-B-T-2221-B-L2C-S1, approved drawings, the WQCP, Contract Special Provisions and AWS D1.5.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations at the time of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Kelsey,David	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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